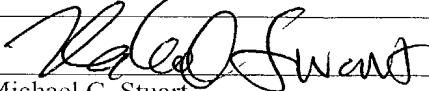


FORM PTO-1390 (REV 10-94)	U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE			DOCKET #: 3397-114PUS
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371				
				U.S. APPLICATION NO. <small>(Unknown, see 37 CFR 1.5)</small> 107088457
INTERNATIONAL APPLICATION NO PCT/FI00/00817		INTERNATIONAL FILING DATE 22 September 2000		PRIORITY DATE CLAIMED 24 September 1999
TITLE OF INVENTION Method and Assembly for Opening Calender Nips				
APPLICANT(S) FOR DO/FO/US Helena LEPPÄKOSKI; Pekka KOIVUKUNNAS				
<p>Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:</p> <ol style="list-style-type: none"> 1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371. 2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371 3. <input checked="" type="checkbox"/> This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1). 4. <input checked="" type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date. 5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2)) <ul style="list-style-type: none"> a. <input checked="" type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau). b. <input type="checkbox"/> has been transmitted by the International Bureau. c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US) 6. <input type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)). 7. <input checked="" type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3)) <ul style="list-style-type: none"> a. <input checked="" type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau). (See Reply to Written Opinion) <ul style="list-style-type: none"> b. <input type="checkbox"/> have been transmitted by the International Bureau. c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired. d. <input type="checkbox"/> have not been made and will not be made. 8. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)). 9. <input checked="" type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)). 10. <input type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)). <p>Items 11. to 16. Below concern other document(s) or information included:</p> <ol style="list-style-type: none"> 11. <input checked="" type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98. 12. <input checked="" type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. 13. <input checked="" type="checkbox"/> A FIRST preliminary amendment. <ul style="list-style-type: none"> <input type="checkbox"/> A SECOND or SUBSEQUENT preliminary amendment. 14. <input type="checkbox"/> A substitute specification. 15. <input type="checkbox"/> A change of power of attorney and/or address letter. 16. <input checked="" type="checkbox"/> Other items or information (<i>specify</i>): PCT Publication Sheet, Int'l Preliminary Examination Report, Reply to Written Opinion, PCT Request, PCT Demand, Notification of the Recording of a Change 				

U.S. APPLICATION NO. (If known, see 37 CFR 1.15) 10/088457	INTERNATIONAL APPLICATION NO PCT/FI00/00817	ATTORNEY'S DOCKET NUMBER 3397-114PUS
17. [x] The following fees are submitted:		
Basic National Fee (37 CFR 1.492(a)(1)-(5)):		
Search Report has been prepared by the EPO or JPO \$890.00		
International preliminary examination fee paid to USPTO (37 CFR 1.482)..... \$710.00		
No international preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2))..... \$740.00		
Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$1040.00		
International preliminary examination fee paid to USPTO (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4) .. \$100.00		
ENTER APPROPRIATE BASIC FEE AMOUNT = \$ 890		
Surcharge of \$130.00 for furnishing the oath or declaration later than [] 20 [] 30 months from the earliest claimed priority date (37 CFR 1.492(e)).		
Claims	Number Filed	Number Extra
Total Claims	12 - 20 =	0
Independent Claims	3 - 3 =	0
Multiple dependent claim(s) (if applicable)		+ \$280.00
TOTAL OF ABOVE CALCULATIONS = \$ 890		
Reduction of $\frac{1}{2}$ for filing by small entity, if applicable.		
SUBTOTAL = \$ 890		
Processing fee of \$130.00 for furnishing the English translation later than [] 20 [] 30 months from the earliest claimed priority date (37 CFR 1.492(f)).		
TOTAL NATIONAL FEE = \$ 890		
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by the appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property		
+ \$ 40		
TOTAL FEES ENCLOSED \$930		
		Amount to be refunded: \$
		charged: \$
<p>a. [x] Two checks in the amounts of <u>\$40</u> and <u>\$890</u> to cover the above fees are enclosed. b. [] Please charge my Deposit Account No. <u>03-2412</u> in the amount of \$_____ to cover the above fees. A duplicate copy of this sheet is enclosed. c. [x] The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. <u>03-2412</u>. A duplicate copy of this sheet is enclosed.</p>		
<p>NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.</p>		
SEND ALL CORRESPONDENCE TO <u>Michael C. Stuart</u> Cohen, Pontani, Lieberman & Pavane 551 Fifth Avenue, Suite 1210 New York, New York 10176		 <u>Michael C. Stuart</u> Registration Number: 35,698 March 15, 2002 Tel: (212) 687-2770

By Express Mail # EL489597455US · March 15, 2002

Attorney Docket # 3397-114PUS

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re National Phase PCT Application of

Helena LEPPÄKOSKI et al.

International Appln. No.: PCT/FI00/00817

International Filing Date: 22 September 2000

For: Method and Assembly for Opening Calender
Nips

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents

Washington, D.C. 20231

BOX PCT

SIR:

Prior to examination of the above-identified application, amend the application as follows:

IN THE SPECIFICATION:

Page 1, delete the paragraph from line 3 to line 8 with the following title, paragraph and title:

--FIELD OF THE INVENTION--

The present invention relates to a method and an assembly for opening calender nips, especially upon the occurrence of break in a web being calendered. The invention also relates to a method for detecting a break in a moving web.

BACKGROUND OF THE INVENTION--

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Page 2, line 29, replace the paragraph ending on page 3, line 13 with the following rewritten paragraph:

--As the web being calendered may in some cases break during calendering, either prior to or after the calendering step, it is necessary to have an ability to open the calender nips as rapidly as possible at the occurrence of a web break. Opening the nips is particularly important in calenders having soft-coated rolls. Namely, the thermorolls of closed nips begin after the web break to heat the adjacent soft-coated rolls because there is no more paper web running through the nip so as to remove the heat emitted by the thermorolls. Consequently, the soft-coated rolls may overheat resulting in a roll becoming damaged. In modern calenders running at high web speeds, also the amount of heat transferred to the thermorolls may be substantially large, which means that an extremely rapid opening of a thermoroll nip is mandatory, even as fast as a few tenths of a second if the web break occurs just upstream from a nip.--.

Page 4, before line 1, the paragraph beginning with "It is an object", insert the following title:

--SUMMARY OF THE INVENTION--.

Page 5, delete the three paragraphs from line 4 to line 14.

Page 6, before line 14, the paragraph beginning with "In the following", insert the following paragraph and title:

-- Other objects and features of the present invention will become apparent from the following detailed description considered in conjunction with the accompanying drawings. It is to be understood, however, that the drawings are intended solely for purposes of illustration and not as a definition of the limits of the invention, for which reference should be made to the appended claims.

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BRIEF DESCRIPTION OF THE DRAWINGS--

Page 6, before line 18, the paragraph beginning with "Referring to", insert the following title:

--DETAILED DESCRIPTION OF THE PRESENTLY PREFERRED EMBODIMENTS--.

Page 11, after the last line, insert the following paragraph:

--Thus, while there have been shown and described and pointed out fundamental novel features of the present invention as applied to a preferred embodiment thereof, it will be understood that various omissions and substitutions and changes in the form and details of the devices described and illustrated, and in their operation, and of the methods described may be made by those skilled in the art without departing from the spirit of the present invention. For example, it is expressly intended that all combinations of those elements and/or method steps which perform substantially the same function in substantially the same way to achieve the same results are within the scope of the invention. Substitutions of elements from one described embodiment to another are also fully intended and contemplated. It is also to be understood that the drawings are not necessarily drawn to scale but that they are merely conceptual in nature. It is the intention, therefore, to be limited only as indicated by the scope of the claims appended hereto.--.

Page 12, line 1, delete "Claims:" and insert therefor --What is claimed is:--.

IN THE CLAIMS:

Amend claims 5, 6, 9, 10, 11 and 12 to read as follows:

5. Method according to claim 1, characterized in that the tension of the web (5) being calendered is measured indirectly by way of measuring the pressure of an air cushion formed between the moving web (5) and a gauging bar, which is located in a close proximity

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to said web (5) and has an at least partially arcuate shape in the travel direction of said web (5), whereby the measured pressure of said air cushion is proportional to the tension of said web (5).

6. Method according to claim 1, characterized in that the web (5) being calendered is severed with the help of an air-jet cutting device when a decision-making algorithm monitoring the tension profile of said web (5) interprets the detected situation to be caused by a web break or other damaged area of the web (5) that necessitates the opening of the nips (9, 10).

9. Assembly according to claim 7, characterized in that said gauging device (8) is located at a point after said calender nip (9, 10) downstream in regard to the travel direction of the web (5).

10. Assembly according to claim 7, characterized in that said gauging device (6, 7, 8) is a gauging bar shaped to have an at least partially arcuate surface in the travel direction of said web (5) and has pressure sensors adapted to holes made thereon.

11. Assembly according to claim 7, characterized in that one of the members (1, 2; 3, 4) forming said calender nip (9, 10) is metal-surfaced roll and the other one is soft-coated roll.

12. Assembly according to claim 7, characterized by an air-jet cutting device adapted to perform the severing of said web (5) being calendered at the instant the decision-making algorithm monitoring interprets the situation to be a web break or a so extensively damaged area of the web (5) that requires the opening of the nips (9, 10).

வினா என்று அறிவுபொருள் என்று கூற விரும்புகிறது.

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REMARKS

This preliminary amendment is presented to place the application in proper form for examination and to eliminate multiple dependency from the present claims. No new matter has been added. Early examination and favorable consideration of the above-identified application is earnestly solicited.

Attached hereto is a mark-up version of the changes made to the specification and claims by the current amendment. The attached page is captioned "Version with markings to show changes made".

Any additional fees or charges required at this time in connection with the application may be charged to our Patent and Trademark Office Deposit Account No. 03-2412.

Respectfully submitted,
COHEN, PONTANI, LIEBERMAN & PAVANE

By: Michael C. Stuart
Michael C. Stuart
Reg. No. 35,698
551 Fifth Avenue, Suite 1210
New York, N.Y. 10176
(212) 687-2770

15 March 2002

10/088457
581 Rec'd PCT/ 15 MAR 2002

By Express Mail # EL489597455US March 15, 2002

**AMENDMENTS TO THE SPECIFICATION AND CLAIMS SHOWING CHANGES
IN THE SPECIFICATION:**

Page 2, line 29, amend the paragraph ending on page 3, line 13 as follows:

--As the web being calendered may in some cases break during calendering, either prior to or after the calendering step, it is necessary to have an ability to open the calender nips as rapidly as possible at the occurrence of a web break. Opening the nips is particularly important in calenders having soft-coated rolls. Namely, the thermorolls of closed nips begin after the web break to heat the adjacent soft-coated rolls because there is no more [a] paper web running through the nip so as to remove the heat emitted by the thermorolls. **[Herein] Consequently**, the soft-coated rolls may overheat resulting in a roll **[damage] becoming damaged**. In modern calenders running at high web speeds, also the **[amounts] amount** of heat transferred to the thermorolls may be substantially large, which means that an extremely rapid opening of a thermoroll nip is mandatory, even as fast as **[in] a few tenths of a second** if the web break occurs just upstream from a nip.--.

IN THE CLAIMS:

5. Method according to **[any one of foregoing claims]** **claim 1**, characterized in that the tension of the web (5) being calendered is measured indirectly by way of measuring the pressure of an air cushion formed between the moving web (5) and a gauging bar, which is located in a close proximity to said web (5) and has an at least partially arcuate shape in the travel direction of said web (5), whereby the measured pressure of said air cushion is proportional to the tension of said web (5).

6. Method according to **[any one of foregoing claims]** **claim 1**, characterized in that the web (5) being calendered is severed with the help of an air-jet cutting device when a decision-making algorithm monitoring the tension profile of said web (5) interprets the detected

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situation to be caused by a web break or other damaged area of the web (5) that necessitates the opening of the nips (9, 10).

9. Assembly according to claim 7 [**or 8**], characterized in that said gauging device (8) is located at a point after said calender nip (9, 10) downstream in regard to the travel direction of the web (5).

10. Assembly according to [**any one of claims 7-9**] **claim 7**, characterized in that said gauging device (6, 7, 8) is a gauging bar shaped to have an at least partially arcuate surface in the travel direction of said web (5) and has pressure sensors adapted to holes made thereon.

11. Assembly according to [**any one of foregoing claims**] **claim 7**, characterized in that one of the members (1, 2; 3, 4) forming said calender nip (9, 10) is metal-surfaced roll and the other one is soft-coated roll.

12. Assembly according to [**any one of foregoing claims**] **claim 7**, characterized by an air-jet cutting device adapted to perform the severing of said web (5) being calendered at the instant the decision-making algorithm monitoring interprets the situation to be a web break or a so extensively damaged area of the web (5) that requires the opening of the nips (9, 10).

PTO/PCT Rec'd 15 MAR 2002

Method and assembly for opening calender nips

The present invention relates to a method according to the preamble of claim 1 and an assembly according to the preamble of claim 7 for opening calender nips especially at breaks occurring in a web being calendered. The invention also relates to a method according to the preamble of claim 14 for detecting a break in a moving web.

Conventionally, the surface of a moving web of paper or board is smoothed and made glossy in a multiroll calender comprising a plurality of rolls stacked in a calender frame so as to form a nip contact with each other. A multiroll calender comprises a top roll and a bottom roll with at least one intermediate roll located therebetween. The rolls of the stack are compressed against each other by the top and bottom rolls that act as the loading rolls to provide a sufficiently high linear nip force. In calendering, the web passes through the calender nips formed by the superimposed rolls. A soft-roll calender typically has two or four nips placed in a succession in separate calender frame sections thus allowing the web being calendered to pass straight between two successive nips. In a conventional two-nip soft-roll calender, the web is calendered once on either side.

Some of the calender rolls are heatable, hard-surfaced thermorolls, while some others are rolls surfaced with a soft coating. For instance, one of the rolls in a roll pair of a soft-roll calender is generally a metal-surfaced thermoroll and the other is soft-coated roll. The thermoroll is typically heated with oil or some other

heat-transfer medium such as water or steam. Using oil as the heating medium, a roll temperature of almost 300 °C can be reached. However, the temperature of the thermoroll is typically about 200 °C. Circulation of the heat-transfer medium in the roll can be accomplished in different ways. The most frequently employed technique is to feed the heat-transfer medium into and out from the roll via a single end only, whereby the medium first is passed along one duct to the roll end and then the return flow takes place along a parallel duct. The return flow exits the roll to a reheating circuit via a bore made to the roll end flange and the roll shaft.

In the material selection for soft-coated rolls, the possible temperature elevation caused by an adjacent thermoroll must be taken into account. The surface coverings of soft-coated rolls are selected from the group of materials compatible with the rugged conditions imposed by the nip contact, such as a generally available polymer of the thermosetting or thermoplastic type, for instance. Rolls coated with a thermoplastic polymer are described in, e.g., publication GB 1,011,114, while rolls coated with a thermosetting polymer are described in, e.g., publication EP 321,561. In the prior art it was conventional to make the covering of soft-coated rolls from natural-fiber-based materials such as those described in, e.g., publication US 4,283,821.

As the web being calendered may in some cases break during calendering, either prior to or after the calendering step, it is necessary to have an ability to open the calender nips as rapidly as possible at the occur-

rence of a web break. Opening the nips is particularly important in calenders having soft-coated rolls. Namely, the thermorolls of closed nips begin after the web break to heat the adjacent soft-coated rolls because there is no more a paper web running through the nip so as to remove the heat emitted by the thermorolls. Herein, the soft-coated rolls may overheat resulting in a roll damage. In modern calenders running at high web speeds, also the amounts of heat transferred to the thermorolls may be substantially large, which means that an extremely rapid opening of a thermoroll nip is mandatory, even as fast as in few tenths of a second if the web break occurs just upstream from a nip.

To prevent damage to soft-coated rolls, calenders are equipped with automatic web-breakage control that opens the calender nips immediately at a web break. Typically, the occurrence of web breaks is monitored by means of photocell curtains installed over the web in the cross-machine direction. As the detection of a web break must take place in a short time, it is not possible to apply a sufficient filtration to the output signal obtained from the photocells. Hence, a small defect, such as a hole in the web, may be interpreted as a web break even if the defective portion of the web in fact might pass the calender without problems. However, due to the high price of the soft-coated rolls, it is customary to set the control system to open the nips already at the occurrence of the smallest defects. As a consequence of such an erroneous or oversensitive response of the automatic web-breakage control system, the calender nips are opened, which is an ultimate cause to an actual web break.

It is an object of the present invention to overcome the problems of the above-described prior art and to provide an entirely novel method and assembly suited for opening 5 the nips of a calender passing a web being calendered at the instant a web break or damage is detected. It is a further object of the invention to provide an entirely novel method for detecting a break in a moving web.

10 The goal of the invention is achieved by way of measuring the tension profile of the web being calendered at multiple points over the cross-directional width of the web, whereby a proper processing of the measurement signal makes it possible to categorize a detected defect 15 as an actual web break necessitating the opening of the nips or as a damaged surface area or minor defect of the web that may be assumed to pass the calender without major problems. The web tension profile may be measured, e.g., by arranging the moving web to pass over an arcuate 20 tension gauging bar. The tension gauging bar is provided with holes communicating with sensors mounted at the holes so that the local pressure of the air cushion formed between the moving web and the gauging bar can be measured. The pressure of the air cushion at a given 25 point is proportional to the web tension at said point. The calender nips are opened when the web tension at a preset number of points over the cross-machine width of the web has fallen to a value at which the decision-making algorithm monitoring the overall tension profile 30 of the web interprets the situation as a web break or an extensive defect on the web that requires the opening of the nips. The web tension may be measured, e.g., in front

of the calender, after the calender or between two nips thereof.

More specifically, the method according to the invention
5 for opening the nips of a calender is characterized by
what is stated in the characterizing part of claim 1.

The assembly according to the invention for opening the
nips of a calender is characterized by what is stated in
10 the characterizing part of claim 7.

Furthermore, the method according to the invention for
detecting breaks in a running web is characterized by
what is stated in the characterizing part of claim 14.

15

The invention offers significant benefits.

By way of monitoring the cross-machine tension profile of
the web being calendered, it is possible to discriminate
20 web breaks and other major defects from such minor
defects that can be expected to pass the calender without
problems in a manner significantly more reliable than
what can be attained through the use of photocells. By
the same token, web breaks induced by an incorrect
25 interpretation of web monitoring signals are reduced,
thus contributing to a higher availability of the
calender and reduced amount of broke. In the embodiment
according to the invention, it is possible to define
optimally the area of maximum web damage, and the respec-
30 tive tension profile, that still permits the respective
portion of the web to be passed through the calender
without encountering major problems. Moreover, it is

possible to detect the damaged portion of the web by virtue of the web tension profile measurement before the web is passed through the calender, thus giving a highly reliable technique of opening the nips before damage is caused to the soft-coated rolls. As the preset web tension monitoring values triggering the opening of the nips can be easily changed, the arrangement according to the invention is easily applicable to different paper grades. Furthermore, the apparatus used for web tension measurement has a relatively simple construction that can be easily adapted to operate in conjunction with an existing calender.

In the following, the invention will be examined in greater detail by making reference to the appended drawing representing diagrammatically a two-nip calender.

Referring to the drawing, the calender construction shown therein comprises two nips 9, 10 formed by members brought into a nip contact, such as rolls and/or the shoes of a shoe press. In the embodiment illustrated in the drawing, the nip 9 is formed by rolls 1, 2 and the nip 10 is formed by rolls 3, 4. Typically, one of the rolls 1-4 forming the nips 9, 10 is a hard-surfaced thermoroll heated by oil, steam or water, while the other roll of the nip is a soft-coated roll. In a conventional two-nip calender, the web 5 is passed almost straight through the nips 9, 10. As the pressure imposed thereon causes the web 5 to increase in width in the first nip 9, there are conventionally placed a number of guide and spread rolls between the nips 9, 10 so that the web 5 can be spread and tensioned. Generally, the rolls 1-4 of a

soft-roll calender are arranged so that the web 5 passing the nips 9, 10 can be calendered on both sides, whereby the hard-surfaced and the soft-coated roll 1, 2 of the first nip 9 are placed in a reversed order in regard to 5 that of the rolls 3, 4 of the second nip 10. In the drawing, the travel direction of the web 5 is denoted by an arrow.

In the travel direction of the web 5 being calendered, at 10 a point preceding the first nip 9, there is placed a gauging device 6 that measures the cross-machine tension profile of the web 5. A similar gauging device 7, 8 is also placed at a point between the nip 9 and the next nip 10, as well as to a point downstream from the nip 10 in 15 the travel direction of the web 5. Alternatively, the gauging device can be located at only one or two of the above-mentioned points, whereby the gauging device is most advantageously placed upstream from the nips 9, 10 in regard to the travel direction of the web 5.

20 The device 6, 7, 8 measuring the tension profile of the web being calendered may be, e.g., an arcuate sensor bar incorporating a plurality of holes aligned in a row essentially at right angles in regard to the web travel 25 direction, each one of the holes having a separate pressure sensor communicating therewith. The web 5 being calendered passes over the sensor bar 6, 7, 8 supported by an air cushion that is formed when the boundary air layer entrained with the web 5 is compressed between the 30 sensor bar 6, 7, 8 and the web 5. The cross-machine tension profile of the web 5 can be determined by way of measuring the local pressure between the running web 5.

and the arcuate section of the sensor bar 6, 7, 8 by means of the pressure sensors communicating with the holes of the sensor bar 6, 7, 8. Obviously, at points where the web 5 is broken or the web 5 has a hole, there 5 cannot be formed any air cushion or, if an air cushion exists, its pressure is lower than at an intact point of the web 5. The structure of one such embodiment of a gauging bar 6, 7, 8 is described, e.g., in more detail in patent publication US 5,052,233.

10

The nips 9, 10 of the calender are opened when the web tension measured at a desired number of cross-machine points of the web 5 have fallen to a limit value at which the decision-making algorithm monitoring the tension 15 profile of the web 5 interprets the situation to be a web break or a so extensively damaged area of the web 5 that requires the opening of the nips 9, 10. Herein, a cross-machine point of the web 5 must be understood to refer to a measurement area monitored by a single sensor or an 20 area of the cross-machine width of the web 5 defined by any other method. When a decision must be made to open the nips 9, 10, it is not necessary to detect an almost complete break of the web 5, but instead, it is generally sufficient to detect a larger defect than that represented 25 by a minor hole in the web 5 or a ragged edge of the web 5.

The decision-making algorithm of the above-described method can be implemented by way of, e.g., giving the 30 cross-machine tension of the web 5 a reference value to which the tension values sensed by the gauging devices 6, 7, 8 are compared. The widths of the areas on the web 5

at the points, where the measured value of the web tension fall below the preset reference value, are summed. Next, the summed width of the defective areas over the cross-machine width of the web 5 falling short of the 5 preset reference value is compared to the overall width of the web 5, whereby any violation of an adjustably-defined preset limit value of damaged area triggers the opening of the nips 9, 10. In other words, the summed width of the areas detected in the web 5 falling short of 10 the preset limit value are herein considered to represent the width of the damaged area in the web 5. For instance, if the web 5 being calendered breaks entirely, the measured tension of the web falls below the preset reference value at least essentially over the entire width of the 15 web 5. Experimental data can be used in the determination of the reference value and the limit value representing the maximum summed width of the damaged areas to the overall width of the web 5 that may be assumed to pass the web 5 through the calender without problems.

20 Generally, there must be determined different reference and limit values for each one of the paper grades to be produced. Obviously, it is necessary to provide possibilities of changing the settings of the reference and limit values when the properties of the paper web 25 being calendered vary.

Another technique of setting up the decision-making algorithm is to compute, e.g., a weighted average of the measurement values obtained from the different points 30 over the cross-machine width of the web and then to open the nips 9, 10 when this value falls below the preset reference value. Typically, the weighing factor in the

averaging computation is set proportional to the width of the measurement point in question.

The decision-making algorithm may also be designed to
5 implement the above-described functions in a more intel-
ligent manner utilizing, e.g., a model based on statisti-
cal analysis that takes into account, e.g., the magnitude
of the normal variations in the web tension and makes an
inference on a web break when the tension measurement
10 values taken on the web 5 fall significantly below those
expected to be encountered within the random variations
of normal tension measurement data.

The method according to the invention for detecting a
15 break in the web 5 is otherwise similar to the above-
described method for opening calender nips, except that
herein an indication of a web break is triggered when in
the web 5 the summed width of the areas at which the
measured tension value of the web 5 falls below a preset
20 reference value becomes at least essentially equal to the
overall width of the web 5.

In addition to those described above, the invention may
have alternative embodiments.

25 In spite of the fact that the above arrangement using a
gauging sensor bar for determining the cross-machine
tension profile of the web being calendered can be appre-
ciated as the most preferred embodiment of the invention,
30 also other kinds of equipment suited for the task can be
used. One kind of such apparatuses is a tension measure-
ment roll axially divided in segments having the air-

cushion pressure gauging sensors adapted therein.

As it may be difficult to adapt the web tension measuring equipment into the space remaining between the calender nips in multiroll calenders comprising a plurality of nips formed by superposed rolls, the measurement of the cross-machine web tension profile must in practice be performed either upstream and/or downstream of calender.

10 After the decision-making algorithm has detected a web break or a defective point on the web 5, the web 5 may be severed by means of an air-jet cutting device that cuts the web with the help of a compressed-air jet. After the web has been cut with the help of the compressed-air jet, 15 the web 5 can be guided away from the nips to prevent the web from becoming wound about the calender rolls. In practice, the cutting technique based on an air jet is much safer than a web-cutting technique implemented with cutting knives, for instance. The air-jet cutting 20 apparatus may be integrated, e.g., in the above-described web tension gauging bar.

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Claims:

1. Method for opening the nips (9, 10) of a calender comprising at least two elements (1, 2; 3, 4) brought to a nip contact with each other, especially for performing the nip opening at a break or damage occurring in the web (5) being calendered, in which method the tension of the web (5) being calendered is measured at multiple points over the cross-machine width of the web (5), characterized in that the calender nips (9, 10) are opened when the measured web tension at a preset number of points over the cross-machine width of the web (5) has fallen to a limit value that by a decision-making algorithm monitoring the tension profile of the web (5) is interpreted to indicate a damage on the web (5) requiring opening the nips (9, 10), the decision to open the nips is made before a complete break of the web (5) occurs.
2. Method according to claim 1, characterized in that
 - a reference value is set for the tension of the web (5) measured at a point over the cross-machine width of the web,
 - said measured tension value of the web (5) is compared with said reference value, and
 - the calender nips (9, 10) are opened when the ratio of the areas, at which the measured tension values of the web (5) fall below a preset reference value, as summed over the cross-machine width of the web (5), to the overall width of the web (5) exceeds a preset

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limit value.

3. Method according to claim 1, characterized in that

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- a preset reference value is set for the tension of the web (5) measured at a point over the cross-machine width of the web,
- a weighted average is computed from said measured tension values of the web (5) obtained from different points over the width of the web, and
- the calender nips (9, 10) are opened when said weighted average of the web tension values falls below the preset reference value.

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4. Method according to claim 3, characterized in that the width of the detected area is used as the weighing factor of said weighted average.

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5. Method according to any one of foregoing claims, characterized in that the tension of the web (5) being calendered is measured indirectly by way of measuring the pressure of an air cushion formed between the moving web (5) and a gauging bar, which is located in a close proximity to said web (5) and has an at least partially arcuate shape in the travel direction of said web (5), whereby the measured pressure of said air cushion is proportional to the tension of said web (5).

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6. Method according to any one of foregoing claims, characterized in that the web (5) being calendered is severed with the help of an air-jet

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cutting device when a decision-making algorithm monitoring the tension profile of said web (5) interprets the detected situation to be caused by a web break or other damaged area of the web (5) that necessitates the opening of the nips (9, 10).

5 7. Assembly for opening calender nips (9, 10), particularly at the occurrence of a break or damage in a web (5) being calendered, said assembly comprising

10 - at least two members (1, 2; 3, 4) adapted to cooperate in a nip contact so as to pass there-between the web (5) being calendered, and

15 - a gauging device (6, 7, 8) for measuring the tension of the web (5) being calendered at multiple points along the cross-machine width of the web (5),

20 characterized in that the calender nips (9, 10) are adapted openable when the web tension measured at a preset number of cross-machine points of the web (5) has fallen to a value at which a decision-making algorithm monitoring the tension profile of the web (5) interprets the detected situation to be caused by damaged area of the web (5) that necessitates the opening of the nips (9, 10), the decision to open the nips is made before a complete break of the web (5) occurs.

25 30 8. Assembly according to claim 7, characterized in that said gauging device (6, 7) is located at a point preceding said calender nip (9, 10) upstream in regard to the travel direction of the web (5).

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9. Assembly according to claim 7 or 8, characterized in that said gauging device (8) is located at a point after said calender nip (9, 10) downstream in regard to the travel direction of the web (5).
5
10. Assembly according to any one of claims 7-9, characterized in that said gauging device (6, 7, 8) is a gauging bar shaped to have an at least partially arcuate surface in the travel direction of said web (5) and has pressure sensors adapted to holes made thereon.
10
11. Assembly according to any one of foregoing claims, characterized in that one of the members (1, 2; 3, 4) forming said calender nip (9, 10) is metal-surfaced roll and the other one is soft-coated roll.
15
20. 12. Assembly according to any one of foregoing claims, characterized by an air-jet cutting device adapted to perform the severing of said web (5) being calendered at the instant the decision-making algorithm monitoring interprets the situation to be a web break or a so extensively damaged area of the web (5) that requires the opening of the nips (9, 10).
25
30. 13. Assembly according to claim 12, characterized in that said air-jet cutting device is integrated with said web tension gauging bar.
35. 14. Method for detecting a break or damage occurring in a web (5) being calendered, in which method the machine-direction tension of the web (5) being calendered is measured at multiple points over the cross-machine width of the web (5), characterized

t e r i z e d in that a damage of the web (5) is indicated when the measured web tension at a preset number of points over the cross-machine width of the web (5) has fallen to a limit value that by a decision-making algorithm monitoring the tension profile of the web (5) is interpreted to indicate a damage on the web (5) requiring opening the nips (9, 10), the indication is made before a complete break of the web (5) occurs.

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KOIVUKUNNAS, Pekka [FI/FI]; Tupalantie 13 D 31, FIN-04400 Järvenpää (FI). HASANEN, Kari [FI/FI]; Päivärinteen tie 13 A 6, FIN-04250 Kerava (FI).

(21) International Application Number: **PCT/FI00/00817**

(74) Agent: **SEppo LAINE OY**; Itämerenkatu 3 B, FIN-00180 Helsinki (FI).

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(71) Applicant (*for all designated States except US*): **VALMET CORPORATION [FI/FI]**; Fabianinkatu 9 A, FIN-00130 Helsinki (FI).

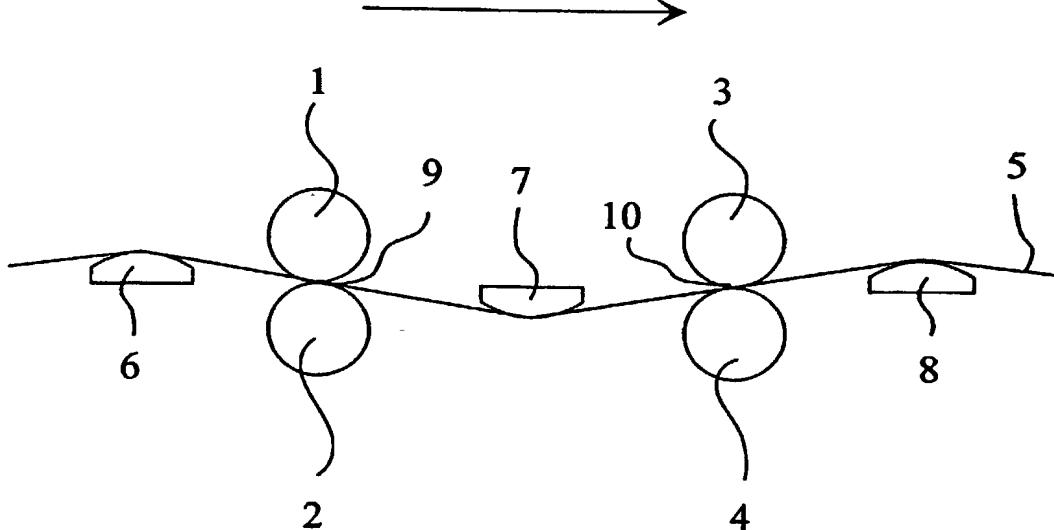
(72) Inventors; and

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(75) Inventors/Applicants (*for US only*): **LEPPÄKOSKI, Helena [FI/FI]**; Sirkuja 6, FIN-04440 Järvenpää (FI).

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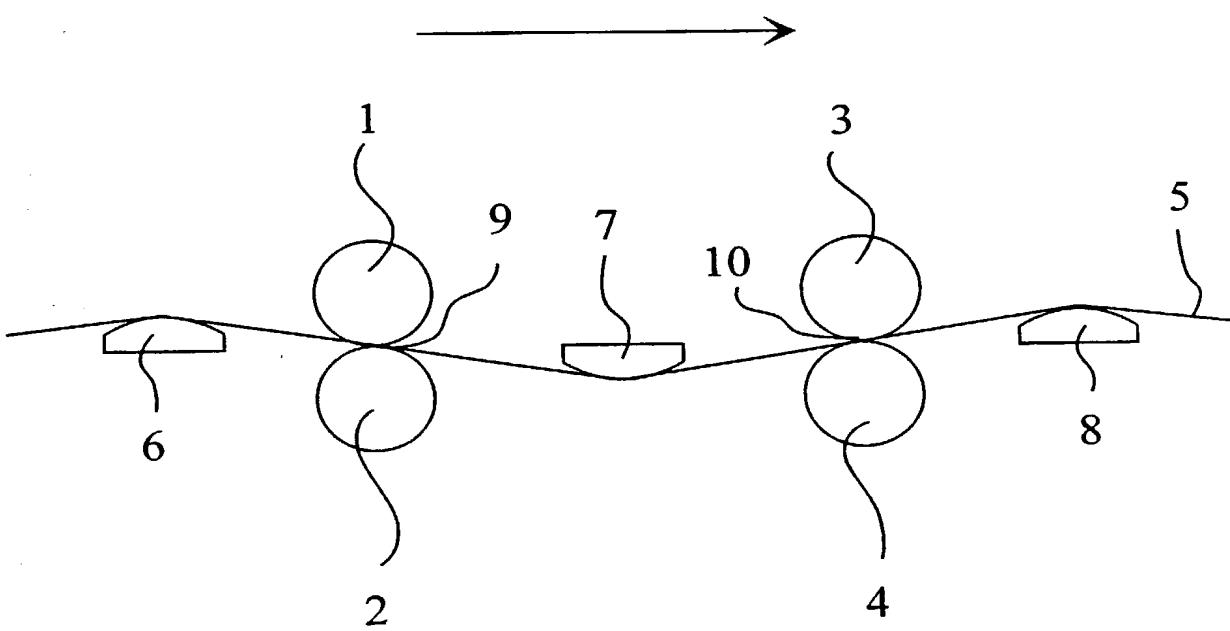
(54) Title: **METHOD AND ASSEMBLY FOR OPENING CALENDER NIPS**



WO 01/21888 A1

(57) Abstract: The present invention relates to a method and assembly for opening the nips (9, 10) of a calender comprising at least two elements (1, 2; 3, 4) brought to a nip contact with each other, especially for performing the nip opening at a break or damage occurring in the web (5) being calendered. The tension of the web (5) being calendered is measured at multiple points over the cross-machine width of the web (5) and the calender nips (9, 10) are opened when the measured web tension at a preset number of points over the cross-machine width of the web (5) has fallen to a limit value that by a decision-making algorithm monitoring the tension profile of the web (5) is interpreted to indicate a web break situation or other damage on the web (5) requiring opening the nips (9, 10).

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As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

the specification of which (check only one item below)

is attached hereto

was filed as United States application

Serial No. _____

on _____

and was amended

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was filed as PCT international application

Number PCT/FI00/00817

on September 22, 2000

and was amended under PCT Article 19

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I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the patentability of the application in accordance with Title 37, Code of Federal Regulations, §1.56(a).

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate or of any PCT international application(s) designating at least one country other than the United States of America listed below and have also identified below any foreign application(s) for patent or inventor's certificate or any PCT international application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed.

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Country (if PCT, indicate "PCT")	Application Number	Date of Filing (day, month, year)	Priority Claimed Under 35 U.S.C. 119	
Finland	19992058	Sept. 24, 1999	<input checked="" type="checkbox"/> YES	<input type="checkbox"/> NO
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PCT/FI00/00817	September 22, 2000			

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith (*List name and registration number*)

12 MYRON COHEN, Reg. No. 17,358; THOMAS C. PONTANI, Reg. No. 29,763; LANCE J. LIEBERMAN, Reg. No. 28,437; MARTIN B. PAVANE, Reg. No. 28,337; MICHAEL C. STUART, Reg. No. 35,698; KLAUS P. STOFFEL, Reg. No. 31,668; EDWARD M. WEISSZ, Reg. No. 37,257; CHI K. ENG, Reg. No. 38,870; JULIA S. KIM, Reg. No. 36,567; VINCENT M. FAZZARI, Reg. No. 26,879; ALFRED W. FRÖEBRICH, Reg. No. 38,887. 37,897; ANDRES N. MADRID, Reg. No. 40,710

Send correspondence to:

Michael C. Stuart
Reg. No. 35,698
Cohen, Pontani, Lieberman & Pavane
551 Fifth Avenue, Suite 1210
New York, New York 10176

Direct Telephone calls to:
(name and telephone number)

Michael C. Stuart
(212) 687-2770

1	FULL NAME OF INVENTOR	FAMILY NAME Leppäkoski	FIRST GIVEN NAME Helena	SECOND GIVEN NAME
2	RESIDENCE & CITIZENSHIP	CITY Lempäälä	STATE OR FOREIGN COUNTRY Finland <i>FIX</i>	COUNTRY OF CITIZENSHIP Finland
0	POST OFFICE ADDRESS	POST OFFICE ADDRESS Pajatie 14	CITY Lempäälä	STATE & ZIP CODE/COUNTRY FIN-37560 Finland
1	FULL NAME OF INVENTOR	FAMILY NAME Koivukunnas	FIRST GIVEN NAME Rekka	SECOND GIVEN NAME
2	RESIDENCE & CITIZENSHIP	CITY Järvenpää	STATE OR FOREIGN COUNTRY Finland <i>FIX</i>	COUNTRY OF CITIZENSHIP Finland
0	POST OFFICE ADDRESS	POST OFFICE ADDRESS Kauhavankuja 5	CITY Järvenpää	STATE & ZIP CODE/COUNTRY FIN-04430 Finland
2				

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2 0 3	FULL NAME OF INVENTOR	FAMILY NAME <u>Hasanen</u>	FIRST GIVEN NAME <u>Kari</u>	SECOND GIVEN NAME
	RESIDENCE & CITIZENSHIP	CITY <u>Kerava</u>	STATE OR FOREIGN COUNTRY <u>Finland</u> <i>-LX</i>	COUNTRY OF CITIZENSHIP <u>Finland</u>
	POST OFFICE ADDRESS	POST OFFICE ADDRESS <u>Päivärinteentie 13 A 6</u>	CITY <u>Kerava</u>	STATE & ZIP CODE/COUNTRY <u>FIN-04250 Finland</u>
2 0 4	FULL NAME OF INVENTOR	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
	RESIDENCE & CITIZENSHIP	CITY	STATE OR FOREIGN COUNTRY	COUNTRY OF CITIZENSHIP
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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under §1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

SIGNATURE OF INVENTOR 201 <i>Heleen Leyendecker</i>	SIGNATURE OF INVENTOR 202 <i>Peter P</i>	SIGNATURE OF INVENTOR 203 <i>R. Ha</i>
DATE March 1, 2002	DATE March 1, 2002	DATE March 1, 2002
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